



Technical Tip #138 – Choosing the Right Chipbreaker

Applying the correct chipbreaker for the application will help you get the most out of your insert performance.

When choosing the right chipbreaker, first determine two things: the material being machined and the depth of cut.

For example, steels primarily use a negative chipbreaker. Stainless and non-ferrous materials use a positive chipbreaker.

There is range on the depth of cut for chipbreakers.

For example, a finish chipbreaker should not be used for roughing. The roughing cut is a larger depth of cut, and the finish chipbreaker has a weaker edge. The correct chipbreaker will give more performance life to the insert.